

Work Order ID 130153***130153***

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February-25-15 8:49:07 AM

Item ID: D119-796-201

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: AFT Crosstube Installation with Step

Start Date: 2/25/15 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 2/25/15 Req'd Qty: 1.00 ***1***

Customer:

Reference: PULL FROM AGUSTA TRIAL FIT

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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IIN-D119-796

C

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D119-796-201 CHG003

105

0.00

105

Crosstubes

Memo

0.00

Crosstubes

PULL FROM AGUSTA TRIAL FIT
1 x D119-796-201 B128014REMOVE FROM GEAR
TOUCH UP A/R

DAS

41

9-89

15-2-26

-251 B128017

D5149-043 > B128561 x2

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Item ID: D119-796-201

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: AFT Crosstube Installation with Step

Stop *NS2*

Start Date: 2/25/15 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 2/25/15 **Req'd Qty:** 1.00 ***1***

Customer:

Reference: PULL FROM AGUSTA TRIAL FIT

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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108 QC5- Inspect part completeness to step on W/O

0.00

108

QC Memo

0.00

Quality Control

DAS

~~33~~

9-89

75-0226

110	Pick Kit	0.00
-----	----------	------

110

Packaging	Memo	0.00
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Packaging PICK NEW KIT

120	QC4- 100% Inspect kits for completeness	0.00
-----	---	------

120

QC	Memo	0.00
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Quality Control

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Item ID: D119-796-201 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: AFT Crosstube Installation with Step
Start Date: 2/25/15 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 2/25/15 Req'd Qty: 1.00 ***1*** Customer:
Reference: PULL FROM AGUSTA TRIAL FIT

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D119-796-201 Location: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

W 15-0304

Picklist Print

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Work Order ID: 130153

130153

Parent Item: D119-796-201

D119-796-201

Parent Item Name: AFT Crosstube Installation with Step

Start Date: 2/25/15

Required Date: 2/25/15

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP REV:A NEW ISSUE 14-09-05 DD VERF:JLM
REV:B 14.10.22 AS PER PA1 DD VERF:JLM
14.11.19 AS PER IIN REV.B DD VERF:JLM
AS PER REV C JLM VERIFIED BY:DD

IPP
IPP REV:C
IPP REV D 15.02.13

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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AN5C32A

Purchased

No

Each

163.0000

4

AN5C32A

BOLT

use originals
u

Location

Loc Qty

Loc Code

FG

4

18918

4

ST286A

100

131650

100

ST336

59

m130298

17

m131152

42

AN5C7A

Purchased

No

Each

253.0000

12

AN5C7A

BOLT

use originals
u

Location

Loc Qty

Loc Code

FG

2

19185

2

ST286A

150

m131320

150

ST338

101

19185

1

m131139

100

D119-796-201

Manufactured

No

Each

0.0000

1

D119-796-201

AFT Crosstube Installation with Step

u 15-02-26

u 15-02-26

Picklist Print

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Work Order ID: 130153

130153

Parent Item: D119-796-201

D119-796-201

Parent Item Name: AFT Crosstube Installation with Step

Start Date: 2/25/15

Required Date: 2/25/15

Start Qty: 1.00

Required Qty: 1.00

MS21043-5

Purchased

No

Each

184.0000

4

MS21043-5

Nut

Location

Loc Qty

Loc Code

FG

20

101418

20

GA

85

116548

85

ST304

79

m131317

79

MS21250-05-048

Purchased

No

Each

47.0000

4

MS21250-05-048

BOLT

Location

Loc Qty

Loc Code

ST298

47

m131559

17

m131605

30

NAS1149C0563R

Purchased

No

Each

346.0000

20

NAS1149C0563R

Washer

Location

Loc Qty

Loc Code

ST271

346

m125928

5

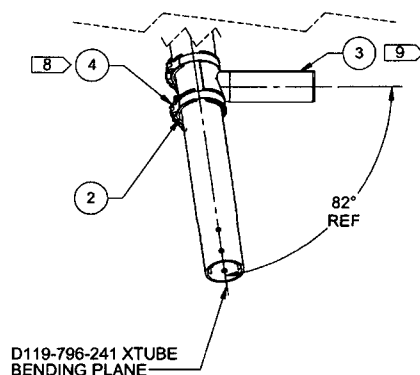
m131026

341

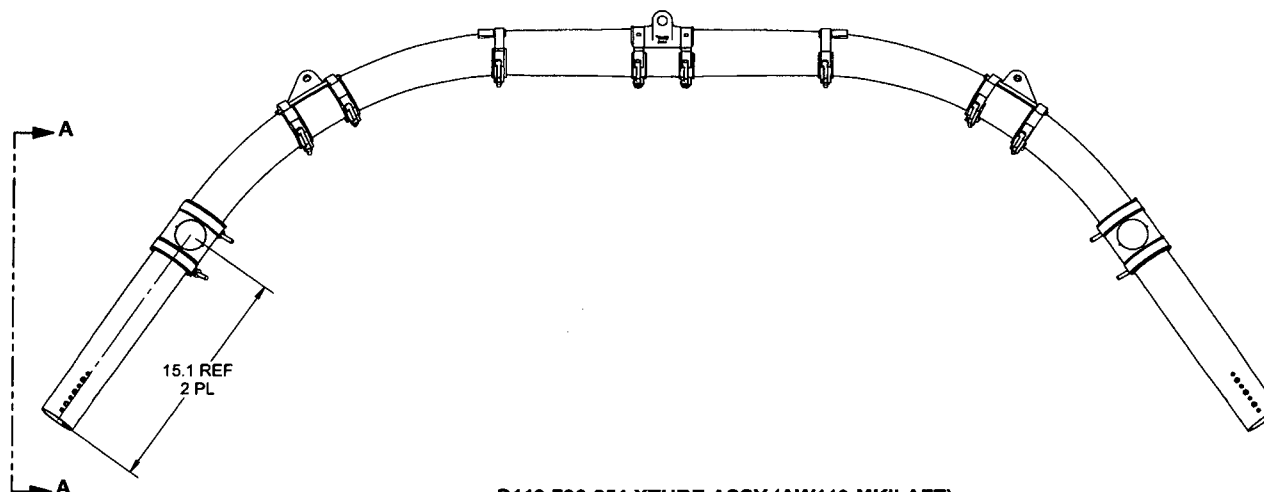
*use originals
(12)*

*add
12 + 8
u 15.0226*

ITEM	QTY -251	P/N	DESCRIPTION
	X	D119-796-251	XTUBE ASSY (AW119 MKII AFT)
1	1	D119-796-241	XTUBE ASSY (AW119 MKII AFT)
2	4	D5123-3	CUSHION
3	2	D5149-043	AFT STEP ASSY
4	4	MS21920-25	CLAMP



SECTION A-A



D119-796-251 XTUBE ASSY (AW119 MKII AFT)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 METHOD 6.5
- 7) WEIGHT: 29.9 lbs
- 8) TORQUE MS21920-25 CLAMPS TO 50 IN-LBS MAX
- 9) LOCATE STEP USING POST FITTING ON CROSSTUBE

RELEASED

2015 FEB 09

ECN 15-516

REV.	DESCRIPTION	BY	DATE
D	D5123-3 WAS D5123-9, MS21920-25 WAS -26, ADDED SECTION A-A	AP	15.01.19
C	RE-DESIGN STEP INSTALLATION	DB	14.11.24
B	D2274 RADIUS BLOCK WAS D5153-1, AN4C12A WAS AN4C10A	AP	14.10.04
A	NEW ISSUE	AP	14.09.03
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	DB	DRAWING NO.	REV. D
MFG. APPR.	DD	D119-796-251	SHEET 1 OF 1
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	XTUBE ASSY (AW119 MKII AFT) NTS	
DATE	15.01.19	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED

Status	Item ID	Rev	Name	Start Date	ntity	JOmp	D.e	Serap	Qumme	d	N.C	Il	Sortie	Offs	n	Ty	Per	ch	to	re	C
	AN5C32A		BOLT	11/19/14	4	Ea			0	0...			3	0	M						
	AN5C7A		BOLT	11/19/14	12	Ea			0	0...			4	0	M						
	D119-796-251		Aft Crosstube, STD w/ Peg Steps (MKII)	10/21/14	1	Ea			0	0...			1	0	M						
	MS21043-5		Nut	10/21/14	4	Ea			0	0...			5	0	M						
	MS21250-05-048		BOLT	2/13/15	4	Ea			0	0...			2	0	M						
	NAS1149C0563R		Washer	10/21/14	20	Ea			0	0...			6	0	M						